

5/14

DART AEROSPACE LTD		Work Order:	22636
Description: Center Divider		Part Number:	D3251-041
Dwg: D3251 Rev. A		Qty:	10 Kit(s)
REF. ICA-D205-577 PAGE 19 & 21 REV. 0		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler	KJ	05.03.09	10																
2	PG	Issue P/O: <u>2057692</u> Fabricate D3251-1 as per Dwg D3251 Possible Supplier: Industrial Laser Material release note is required	U	05.03.10	10																
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/06/08	10																
4	QC6	Inspect dimensions as per Dwg D3251	ml	05/07/04	10																
5	GA	Deburr	ml	05/07/04	10																
6	QC5	Inspect work to Step 5	2	05.08.03	10																
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.08.03	10																
8	QC3	Inspect Chemical Conversion Coat																			
9	GA	Assemble D3251-041 as per Dwg D3251 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3248-1</td><td>Doubler</td><td><u>1322636</u></td></tr><tr><td>1</td><td>D3251-1</td><td>Divider</td><td><u>1322636</u></td></tr><tr><td>18</td><td>MS20470AD4-5</td><td>Rivet</td><td><u>1116163</u></td></tr></table> Identify as D3251-041	Qty	Part Number	Description	Batch	2	D3248-1	Doubler	<u>1322636</u>	1	D3251-1	Divider	<u>1322636</u>	18	MS20470AD4-5	Rivet	<u>1116163</u>	SAD	05/08/12	10
Qty	Part Number	Description	Batch																		
2	D3248-1	Doubler	<u>1322636</u>																		
1	D3251-1	Divider	<u>1322636</u>																		
18	MS20470AD4-5	Rivet	<u>1116163</u>																		
10	QC5	Inspect work to Step 9	2	05.08.16	10																
11	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05.08.16	10																
12	QC3	Inspect Powder Coat	ml	05.08.16	10																
13	ST	Identify and Stock	DL	05/08/18	10																
14	AC	Cost / part																			
15	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	
B	04.10.26	D3251-1 no longer made in-house	KJ/JLM	

RELEASED
20/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-07-06	4	Dimension are good exception 32 Holes should be ϕ .098 Was .090 <i>ml</i>		Re-do 32 Holes .098 as drawing D3251-1 D3251-1	<i>ml</i> 05-07-06			
		and 18 holes should be ϕ .128 <i>ml</i> Was .121 and Pieces are dirty		and 18 holes .128 as per dwn D3251-1 Smooth ground on pieces				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

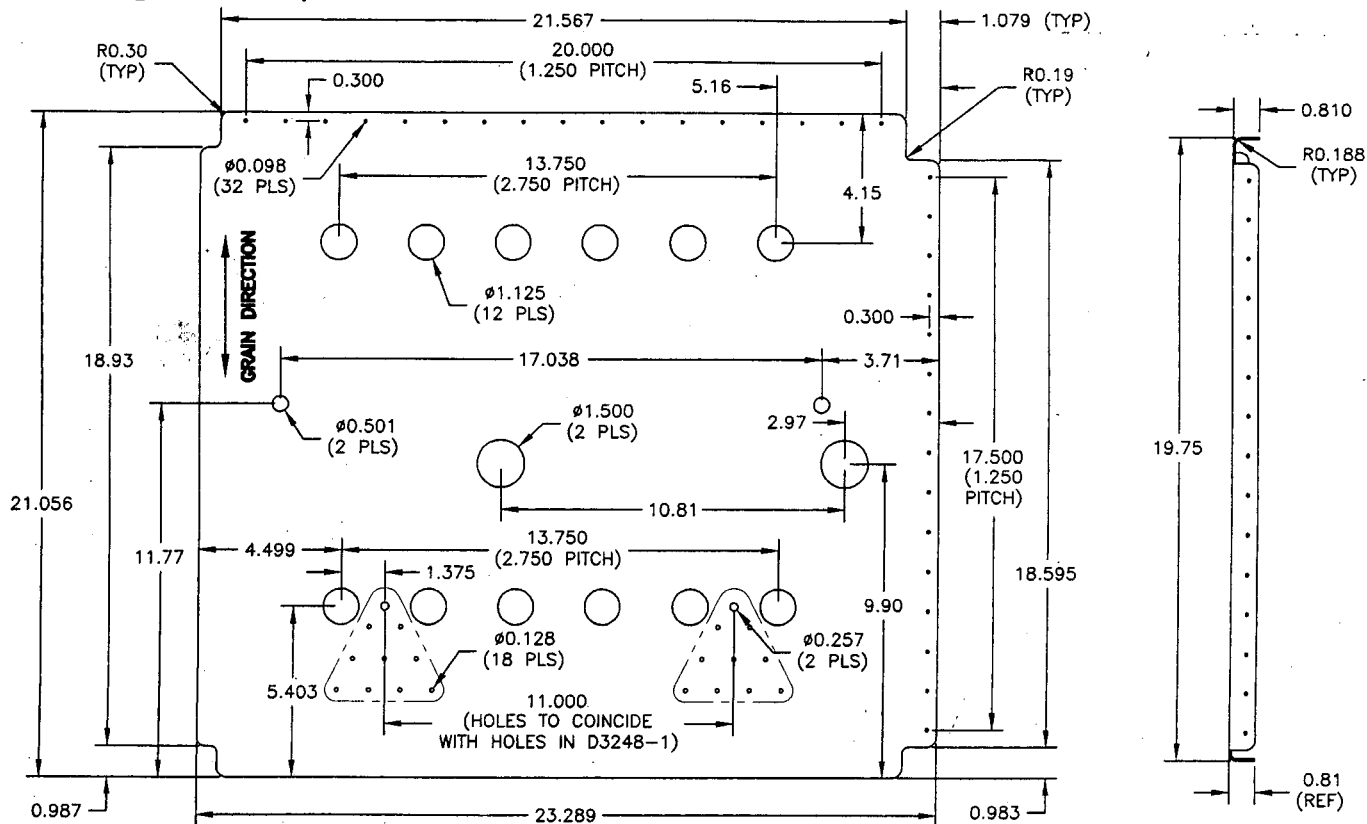
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

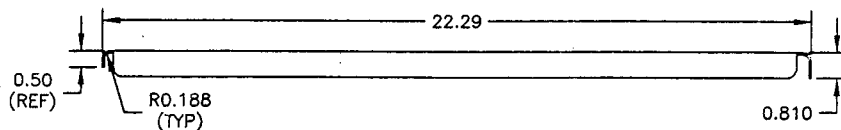


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3251	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE CENTRE DIVIDER (DUAL BATTERY RACK) 1:6	
A	04.04.06	NEW ISSUE	

RELEASED
04.05.04



FLAT PATTERN

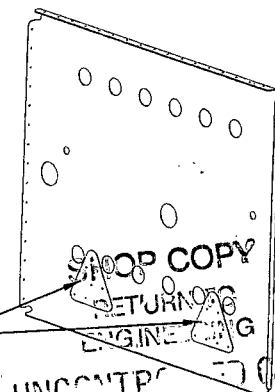


D3251-1 BEND DETAIL

INSTALL D3248-1
USING MS20470A4-5
RIVETS

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S:063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



UNCONTROLLED COPY
D3251-041

WORK ORDER
NO. 22636

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PECHINEY ROLLED PRODUCTS

ALASKAN COPPER & BRASS
4700 COLORADO AVENUE
SEATTLE WA

98124

ALASKAN

T86002 4330

CERTIFIED TEST REPORT

PECHINEY ROLLED PRODUCTS

ALASKAN COPPER & BRASS
P.O. BOX 3546
SEATTLE WA

98124

2

CUSTOMER PURCHASE ORDER NO. & ITEM 16497				PECHINEY ORDER NO. 052-880417	
ALLOY 5052	CLAD. 00	TEMPER H32	GAUGE .06300	WIDTH 48.000	LENGTH .000
ITEM ORDERED RAVENSWOOD DISTRIBUTOR SPEC COIL NON HT MILL					
CUSTOMER SPECIFICATION AMS-QQ-A-250/8					
PART NUMBER			B/L NUMBER T86000		DATE SHIPPED 04-09-03
WEIGHT SHIPPED 13,345		NO. OF PIECES 1		GOVT. CONTRACT NO.	

CERTIFICATION
"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."
PECHINEY ROLLED PRODUCTS
RAVENSWOOD, WV 26164
Mark E. Parsons
MARK E. PARSONS-LABORATORY SUPERVISOR

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		MIN	MAX									
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.											
449461			ACTUAL CHEMICAL COMPOSITION																
			SI=0.10 FE=0.27 CU=0.07 MN=0.05 MG= 2.4 CR=0.18 ZN=0.02 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																
IC	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

PECHINEY ROLLED PRODUCTS

CERTIFIED TEST REPORT

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T86002 4330

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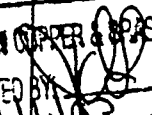
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			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.										
449461	L	2	33.8	33.8	27.6	27.6	9.3	10.9	.0	.0								
ALSO CONFORMS TO ASTM B209																		
<div>ALASKAN COPPER & BRASS CO. APPROVED BY:  DATE: 4/16/03 P.O.: 16497</div>																		
ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
	SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																		

